

Work Order ID 91252

91252

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Thursday, October 04, 2012 11:44:44 AM

Item ID: D350-636-216 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube STD RH, Deluxe
Start Date: 10/4/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/12/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference: REWORK PER ECN 12-650

Approvals: Process Plan: mf Date: 2-10-04 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D350-636	I

170

0.00

170

HandFinish

Hand Finishing

Memo

0.00

PULL FROM STOCK D350-636-216 X 1 B85192

REMOVE D4154-041 X 1 AND SCRAP

REPLACE WITH D4154-041 X 1 (REV E) PER ECN 12-650

*with plate use Q
new Rev
N/AS 3/15/07*

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Quality Control

*AS
27
13.5.8*

DART
Dart Aerospace Ltd.
1270 ABERDEEN ST.
HAWKESBURY, ONTARIO CANADA K6A 1K7

P/N	D350-636-216	CHG	CHG003
DESC.	Skidtube RH	STC	SH99-7
LOT	B85192	STC	SR00646SE
MODEL	AS350/355		

MADE IN CANADA

TO APPROVAL # 09-89
TEL: 1-613-632-5200

02/29/07

PATENTS US #5,735,184 CAN #2,222,416
EUROPEAN # 2,082,685

B91252RH

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Item ID: D350-636-216 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube STD RH, Deluxe
 Start Date: 10/4/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/12/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference: REWORK PER ECN 12-650

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo ID AND STOCK UNDER NEW BATCH NUMBER AT CHANGE 004 UPDATE PAPERWORK	0.00 0.00				1	8	13-5-09	
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						ML5 13-05-13 MF 13-5-10	

NCR: Yes / No

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Picklist Print

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Work Order ID: 91252

Parent Item: D350-636-216

Parent Item Name: Skidtube STD RH, Deluxe

Start Date: 10/4/2012

Required Date: 10/12/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.10.04 new issue DD verf:EC IPP Rev:B 11.04.14 ecn11-553
DD verf:EC IPP Rev:D 112.04.16 AS PER ECN 12-542 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4154-041 Wearplate Assembly		Manufactured	No				Each	2.0000		N/A 1		10/05/07	
				<u>Location</u>				<u>Loc Qty</u>					
				FPI				2					
				90298				2					

NCR: Yes / No

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